



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-201TRN
Job Sheet 173486



Part No: D212-664-201TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Crosstubes-2		
100	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		
110	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		
120	Mori Seiki	1 pcs	3/15/18	3/15/18	0.00	1.33	Mori Seiki TL-40		
130	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC1 QC2		
140	QC	1 pcs	3/15/18	3/15/18	0.00	0.00	QC8		
145	Crosstubes	1 pcs	3/15/18	3/15/18	0.00	0.25	Crosstubes-2		
150	HandFXtube	1 pcs	3/16/18	3/16/18	0.00	0.25	Crosstubes-3		
160	QC	1 pcs	3/16/18	3/16/18	0.00	0.00	QC7-1		
170	Packaging	1 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-1		
180	QC21-SA	1 Ea	3/16/18	3/16/18	0.00	0.00	QC21		

Part Op 100 - 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114 2-Turn first side as per Folio FA114
 Descriptions: 120 - 1-Turn second side as per Folio FA114
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT
 170 - Identify and stock in kanban rack Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6006-129	1	71	0

B123 969

Part Specifications

Specifications could not be found.

Plex 3/2/18 10:47 AM Dart.Gagnon.Michelle



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CANADA
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Container No: S048863



Part: D212-664-201TRN

Job No: 173486

Serial No/Batch: S048863

Revision:

Inspector:

Date: 03/07/18

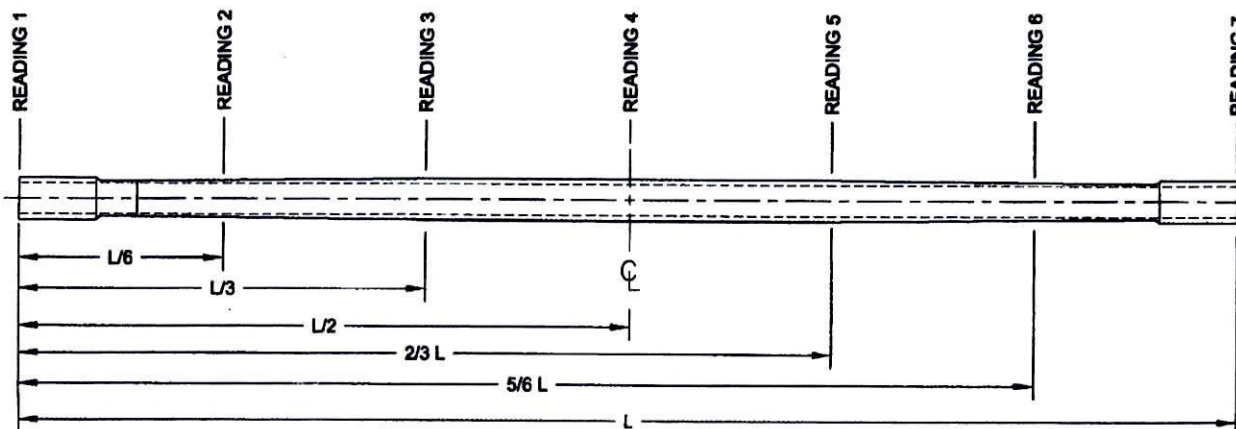
DART AEROSPACE LTD	Work Order:	173486
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	2.000	✓	VERNO8	
	R0.063	+/-0.010	.063	✓	RG	
	2.990	+0.005/-0.000	2.992	✓	VERNO8	
	5.237	+/-0.030	5.240	✓	"	
	2.600	+0.005/-0.000	2.601	✓	BLM 2"3"0"	
	2.686	+0.005/-0.000	2.691	✓	"	
	2.770	+0.005/-0.000	2.775	✓	"	
	2.854	+0.005/-0.000	2.859	✓	"	
	2.938	+0.005/-0.000	2.943	✓	"	
	3.021	+0.005/-0.000	3.0255	✓	BLM 3"4"0"	
	3.133	+0.005/-0.000	3.1375	✓	"	
	3.179	+0.005/-0.000	3.1835	✓	"	
	.500	±.010	.500	✓	RG	
	.063	±.010	.063	✓	RG	
	0.200	+/-0.010	2.000	✓	VERNO8	
SIDE B	R0.063	+/-0.010	.063	✓	RG	
	2.990	+0.005/-0.000	2.992	✓	VERNO8	
	5.237	+/-0.030	5.237	✓	"	
	2.600	+0.005/-0.000	2.605	✓	BLM 2"3"0"	
	2.686	+0.005/-0.000	2.691	✓	"	
	2.770	+0.005/-0.000	2.774	✓	"	
	2.854	+0.005/-0.000	2.858	✓	"	
	2.938	+0.005/-0.000	2.942	✓	"	
	3.021	+0.005/-0.000	3.0255	✓	BLM 3"4"0"	
	3.133	+0.005/-0.000	3.1375	✓	"	
	3.179	+0.005/-0.000	3.1835	✓	"	
	124.362	+/-0.020	124.360	✓	TAPE	
	.500	±.010	.500	✓	RG	
	.063	±.010	.063	✓	RG	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	408	398	396	407	.012	0.062"
READING 2 L = 20.73	309	335	340	317	.031	
READING 3 L = 41.45	488	494	492	485	.009	
READING 4 L = 62.18	518	527	530	522	.012	
READING 5 L = 82.91	483	486	500	500	.017	
READING 6 L = 103.64	322	317	321	330	.013	
READING 7 L = 124.36	421	400	383	396	.038	

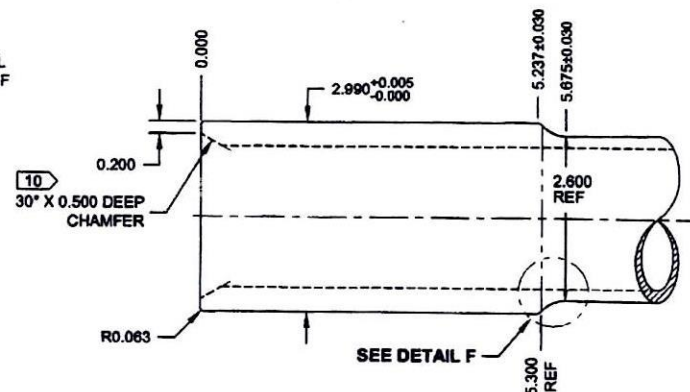
Calibration Result

Actual Block Thickness: 200-500

Sitiescan 250 Measured Thickness: 200-500

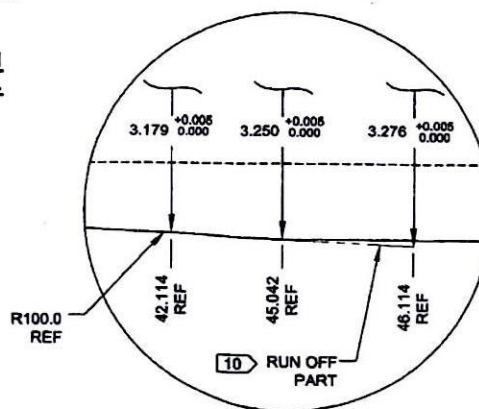
Measured by: PMP	Audited by: JW	Preliminary Approval:
Date: 2018-03-07	Date: 18-03-14	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	



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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173486
MAR 02 2018

RELEASE
2014-05-26



DETAIL E:
TAPER RUN-OFF
NOT TO SCALE

DESIGN	<i>g</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D212-664-241 TITLE CROSSTUBE ASS'Y (205/212 HI AFT) COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF THE BUSINESS OPERATOR THAT IT IS LOANED TO FOR THE PURPOSE OF THE PROJECT. IT IS NOT TO BE REPRODUCED OR COPIED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. 1
DRAWN	<i>g</i>		SHEET 5 OF 5
CHECKED	<i>W</i>		
MFG. APPR.			
APPROVED	<i>W</i>		
DE APPR.	<i>W</i>		
DATE	14.04.01		